

December 21, 2010 1:07:26 PM



Accept

**Setup Start**

Stop



1. *Staphylococcus aureus* (ATCC 12228)
 2. *Staphylococcus aureus* (ATCC 12228)
 3. *Staphylococcus aureus* (ATCC 12228)
 4. *Staphylococcus aureus* (ATCC 12228)
 5. *Staphylococcus aureus* (ATCC 12228)
 6. *Staphylococcus aureus* (ATCC 12228)
 7. *Staphylococcus aureus* (ATCC 12228)
 8. *Staphylococcus aureus* (ATCC 12228)
 9. *Staphylococcus aureus* (ATCC 12228)
 10. *Staphylococcus aureus* (ATCC 12228)

Cust Item ID:

1

Customer:

Reference:

Run Start



Date: 10-12-21 • Tooling:

Date:

QC:

Date:**SPC (Y/N):**

Date:

Stop



120	QC2- Inspect parts off machine FAI/FAIB	0.00		
QC	Memo	0.00	S2 11/01/18	2 1
Quality Control				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3197-041 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: _____ Date: 11/01/20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 11/01/20

NCR: <u>64883</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/18</u>	<u>110</u>	<u>- 1 part has center-drill mark where Ø.191 is</u> <u>- engine was not taken correctly "off center"</u>	<u>11.01.18</u>	<u>SCRAP + Replace Qty +1</u> <u>m. 116604</u>	<u>SL</u> <u>11/01/18</u>	<u>G.A</u> <u>11/01/18</u>	<u>11.01.18</u> <u>OS1042</u>	<u>S</u> <u>11/01/18</u>
		<u>2-G operator error</u> <u>LOA</u>						
		<u>D3197-041</u>						

NOTE: Date & initial all entries

Work Order ID 64883

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Item ID:	D3197-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bar Assembly					
Start Date:	12/21/10	Start Qty:	2.00		Cust Item ID:	
Required Date:	12/30/10	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Lathe Conv Conventional Lathe	CONVENTIONAL LATHE Memo Chamfer as per Dwg D3197	0.00 0.00				2	0		
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2	0		
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	0		

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Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 12/21/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

Memo

0.00

START TIME:

8:15

OVEN TEMPERATURE:

320° FINISH TIME:

8:45

2 BL 11-01-19.

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

ell 11/01/19

x2 0

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3197-041 as per Dwg D3197

G 5/11/01/19 (2)

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Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 12/21/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subtotal

+2

Quality Control

200

Identify as per dwg & Stock Location: 260

0.00



Packaging

Memo

0.00

Packaging

11/01/15 (2)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/19

MF

11-01-29

Picklist Print

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Work Order ID: 64883

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10 NAS1149D0363J Purchased No



Washer

47 M115622 (12X)

Location

Loc Qty

Loc Code

ST 6
107715 6
ST335 2
105792 2

180 Each 8.0000

6 12
EP511/01/19

D2690-5 Manufactured No



Lanyard Assembly

Location

Loc Qty

Loc Code

ST021 14
64533 14

180 Each 14.0000

2 4
EP511/01/19

D3242-1 Manufactured No



Tag

Location

Loc Qty

Loc Code

ST047 2
64531 2

180 Each 2.0000

2 4
EP511/01/19

D3489-3-200 Manufactured No



PIP PIN

Location

Loc Qty

Loc Code

ST62 2
61419 1
64532 1

180 Each 2.0000

2 4
EP511/01/19

B65129 (3X)

Picklist Print

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Work Order ID: 64883

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 2.00

Required Qty: 2.00

M7075T73R1.000

Purchased

No

180

f

8.6000

2.42

6.05



7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT

8.6

115165

5

116405

3.6

116604

6.0500 ft

MS21042L3

Purchased

No

180

Each

1,870.000

2

4



Nut

Location

Loc Qty

Loc Code

ST300

1870

114784

9

115835

957

116373

4

116391

900

4

MS27039-1-24

Purchased

No

100

Each

99.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST292

99

100151

99

4

B.A 11/01/17

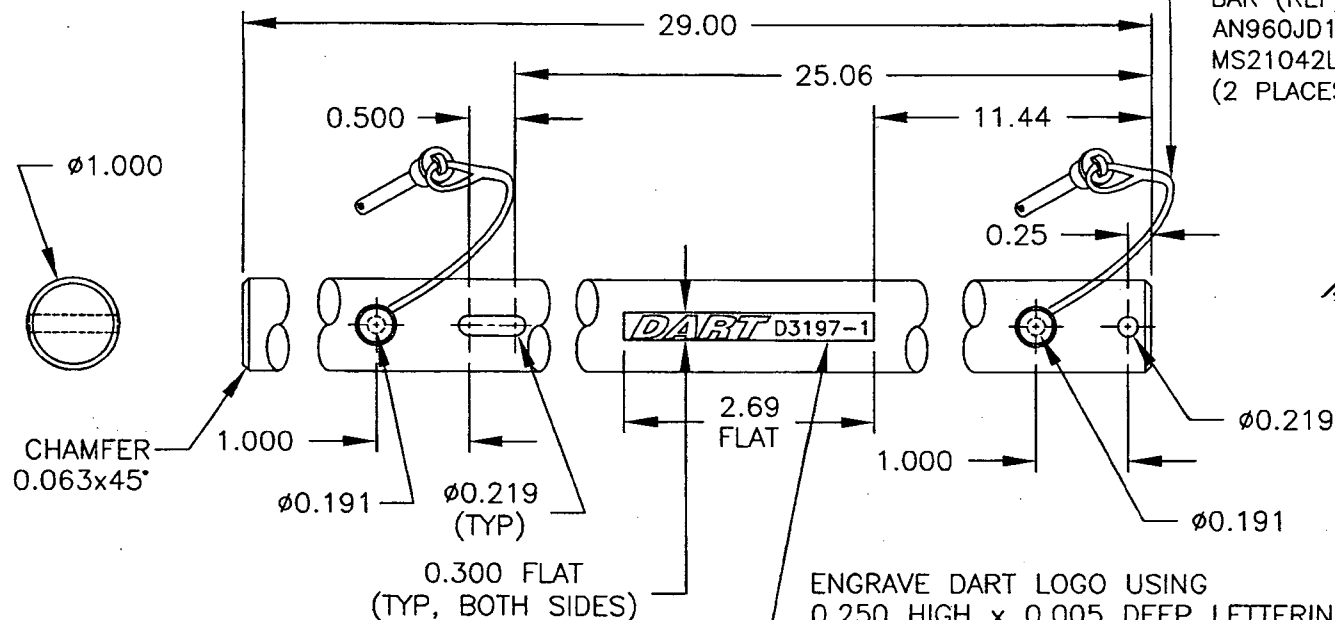
Ep 5/11/01/19

Ep 5/11/01/19

RELEASED

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
		NEW ISSUE		
		CHG PIP PIN: ADD D3242-1 TAG		